

ASAP

# Work Order ID 62196



Page 1

Wednesday, September 22, 2010 10:21:59 A

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 9/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 10-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4154

A

100

0.00



Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH#: 115553

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M114509

3-Transfer drill holes in bar

EL 10-9-22 (X3)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

AEAP

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Page 2

Item ID: D4154-041

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

③ 10.09.30

130



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112528

Memo

0.00

START TIME: 8:35

OVEN TEMPERATURE: 320°

FINISH TIME: 9:05

10.9.30

③ 9

PTO ->

140



QC

Quality Control

QC3- Inspect Part Finish



0.00

Memo

0.00

10/09/30

X3 6

W/O: 62196		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-05	130	As per Milce Pefsky the wearplates should not be powder coated. Remove Powder Coat	M.M.	10/10/05	(3)	 09.2.12	 10-10-05

Part No: D4154-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62196**

Wednesday, September 22, 2010 10:21:59 A

Page 3

Item ID: D4154-041

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Revision ID:

Item Name: Wearplate Assembly

Start Date: 9/22/2010 Start Qty: 4.00

Required Date: 9/29/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3  
dwg D4154.

★ SEE W/O CHG

PTO

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10-10-05

170

Identify as per dwg &amp; Stock Location:

0.00



Packaging

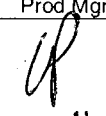
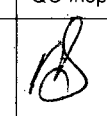
Memo

0.00

Packaging

10/10/12 325

Dart Aerospace Ltd

W/O: 62196		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.04	150	COAT INSIDE SURFACE W/ "PLUS 1 ROCKGUARD" COLOR = BIEGE. BIN M115275	ml.ml	10.10.05	③	 10.10.04 (S) 4/2	 10.10.05

Part No: D4154-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 62196**

Wednesday, September 22, 2010 10:21:59 A

Page 4

Item ID: D4154-041

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Item Name: Wearplate Assembly

Start Date: 9/22/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12  
MF  
10-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, September 22, 2010 10:22:11 AM

Page 1

Work Order ID: 62196

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly





Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1  Plate		Manufactured	No			100	Each	0.0000	1	4			
						B62199	x3					EL 10-9-29	
D4155-1  Bar		Manufactured	No			100	Each	0.0000	1	4			
						<del>B62198</del> B62198	x3					EL 10-9-29.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *602194*

*BS 10-9-22*

**D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2010-09-15

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

TYP

11

D4154-1  
PLATE

A  
A

*Wb 62194*

D4155-1  
BAR

10

10

9

9

9

9

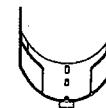
9

9

9

**D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2010-09-15  
JM



**SECTION A-A**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

*→ PLUS 1, ROCKGUARD*

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>UP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>CS</i>	D4154	SHEET 2 OF 3
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

*UP 10.10.04*

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Chris Provencal

---

**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** October 4, 2010 1:42 PM  
**To:** 'David Shepherd'; 'L Lacelle'; 'Sridhar Chintapalli'  
**Cc:** 'David Duval'; 'Chris Provencal'  
**Subject:** RE: D350-636- deluxe

That should be...."beige" ....

---

**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** October 4, 2010 1:43 PM  
**To:** 'Mike Petsche'; 'L Lacelle'; 'Sridhar Chintapalli'  
**Cc:** 'David Duval'; 'Chris Provencal'  
**Subject:** RE: D350-636- deluxe

I agree on both issues.

David

---

**From:** Mike Petsche [mailto:mpetsche@dartaero.com]  
**Sent:** Monday, October 04, 2010 11:35 AM  
**To:** 'L Lacelle'; 'Sridhar Chintapalli'  
**Cc:** 'David Shepherd'; 'David Duval'; 'Chris Provencal'  
**Subject:** RE: D350-636- deluxe

- 1- I think we should go with the being rocker guard stuff rather than proseal...
- 2- Installed

---

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** October 4, 2010 1:33 PM  
**To:** 'Mike Petsche'; 'Sridhar Chintapalli'  
**Cc:** 'David Shepherd'; 'David Duval'  
**Subject:** D350-636- deluxe

Hi,  
2 questions for you guys:

- 1- the drwg for the D4154-041 wearplate says to coat the entire top with sikaflex or proseal...is this correct?
- 2- are the toe step, wedge kit and tow ring kit, just packaged with the tube, or are they installed?

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

No virus found in this incoming message.  
Checked by AVG - [www.avg.com](http://www.avg.com)  
Version: 9.0.856 / Virus Database: 271.1.1/3174 - Release Date: 10/04/10 02:35:00